

# Work Order ID 57973

April 21, 2010 9:53:19 AM



Page 1

Item ID: D4038-9

Accept



Setup Start



Revision ID:

Item Name: Block

Stop



Start Date: 23/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Memo

CUT BLANK 1.750" LONG

0.00

*ml 10/04/24*

4

*0*

105

0.00



HAAS I

Memo

Mill as per Dwg and Folio FA885

DWG REV: *B*

FOLIO REV: *AA*

0.00

*ml 10/04/25*

4

*0*

HAAS CNC vertical machine #1

DEBURR

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*ack 10/04/25*

4

Ø

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*H.A 10/04/26*

4

Ø

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*④ Bk 10-11-26*

# Work Order ID 57973

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Item ID: D4038-9

Accept

Revision ID:

Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

ST 110

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27  
MF 10-4-26

# Picklist Print

April 21, 2010 9:53:18 AM

Page 1

Work Order ID: 57973

Parent Item: D4038-9

Parent Item Name: Block

Comments: lpp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	9.5000	0.6989			



6061-T6 Bar 1:50 x 2.00



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT10	9.5	
110167	9.5	

0.6989 ml 10/04/24

DART AEROSPACE LTD		Work Order: 57973
Description: BLOCK		Part Number: D4038-9
Inspection Dwg: D4038 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

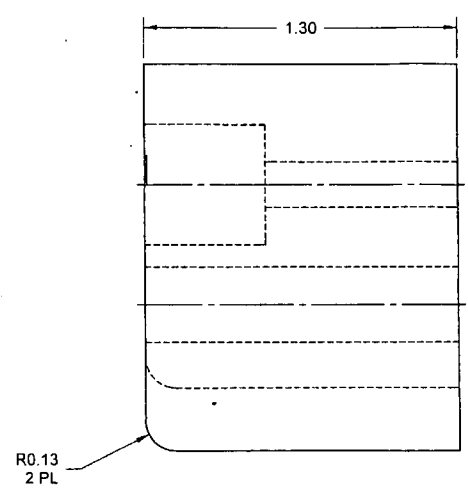
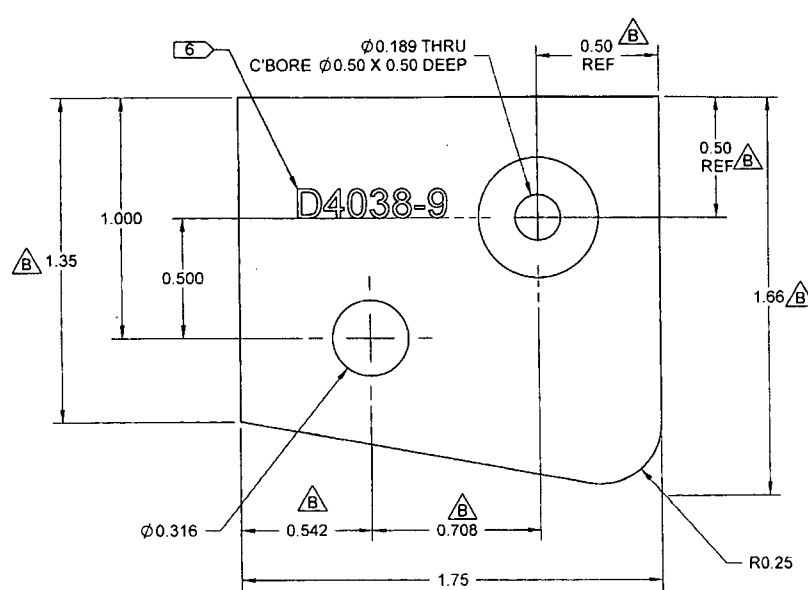
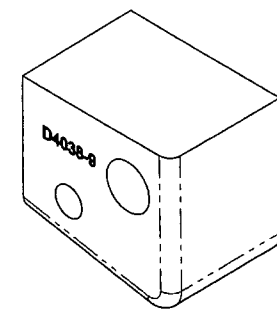
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	$\pm .030$	1.300	✓			
R.13	$\pm .030$	R.125	✓			
<del>1.30</del>						
R.25	$\pm .030$	R.250	✓			
1.75	$\pm .030$	1.751	✓			
.708	$\pm .005$	.700	✓			
.542	$\pm .010$	.542	✓			
Ø.316	$\pm .006$	Ø.317	✓			
.500	$\pm .005$	.501	✓			
1.000	$\pm .010$	1.001	✓			
1.35	$\pm .030$	1.350	✓			
.50	$\pm .030$	.500	✓			
.50	$\pm .030$	.498	✓			
Ø.189	$\pm .007$	Ø.191	✓			
Ø.50 X .50 DEEP	$\pm .030$ X $\pm .030$	Ø.500 X .50	✓			

Measured by: <i>ML</i>	Audited by: <i>H.A</i>	Prototype Approval:	N/A
Date: 10/04/25	Date: 10/04/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

w/0 57973



**D4038-9 BLOCK**

RELEASED  
2010-04-14  
MD

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6051T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4038	SHEET 11 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	